

Work Order ID 128345

January-15-15 2:07:50 PM

128345

Page 1

Item ID: D350-616-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Full Emergency Litter
 Start Date: 1/15/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/30/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-616-011 CHG006								
101		0.00							
101									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per Dwg D2370								
	2- Transfer drill using D4812-041 as template and open to size 0.257" as per Dwg D2370 AND DT9935 DRILL JIG								
	3- Ensure fit of D4812-041 and remove for shipping								
	D4812-041 MUST STAY WITH LITTER FRAME								
	4- Deburr								

*Self
label*

JAN 29 2015

MLJ 15-01-28

*DAS
06
1-09*

1 FF JAN 22 2015

*DAS
128
19-09*

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Item ID: D350-616-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Full Emergency Litter

Stop ***NS2***

Start Date: 1/15/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/30/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

105

QC5- Inspect part completeness to step on W/O

0.00

105

QC

Memo

0.00

Quality Control

DAS
38
9-89

JAN 22 2015

119

Pick Kit

0.00

119

Packaging

Memo

0.00

Packaging

JAN 29 2015

DAS
28
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
06
9-89

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Item ID: D350-616-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Full Emergency Litter

Stop ***NS2***Start Date: 1/15/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/30/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-616-011

Location: 621

PPP Rev: _____

/ JAN 29 2015

DAS
06
5-08

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

ML5

1501-29

Picklist Print

Page 1

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Work Order ID: 128345

128345

Parent Item: D350-616-011

D350-616-011

Parent Item Name: Full Emergency Litter

Start Date: 1/15/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP E03.04.04ReformatKJ/RF

IPP Rev:F 08-12-10 rev.E as per dwg DD verified by:ec IPP REV:G

13.05.21 AS PER DWG REV.G DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2370-1		Manufactured	No				Each	0.0000		1			
D2370-1					127491				**	1	FF	JAN 22 2015	
Litter Frame Assembly													
D350-616-013		Manufactured	No				Each	0.0000		1			
D350-616-013									**		125118		
Deck Plate & Tie Down													
D4812-041		Manufactured	No				Each	7.0000		1			
D4812-041									**		FF	JAN 22 2015	
Patient Stop Assembly													

Location

Loc Qty

Loc Code

ST371

7

124394

1

126501

6

1

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D2370-041	LITTER ASSEMBLY
1	1	D2370-1	LITTER FRAME ASSY
2	1	D4812-041	PATIENT STOP ASSY

D2370-1 LITTER FRAME ASSEMBLY

W/O 128345

D4812-041 PATIENT STOP ASSY

POSITION PATIENT STOP OVER
FWD STUDS AND SECURE
WITH PIP PINS

D2370-041 LITTER ASSEMBLY

RELEASED
2013-05-16
MD

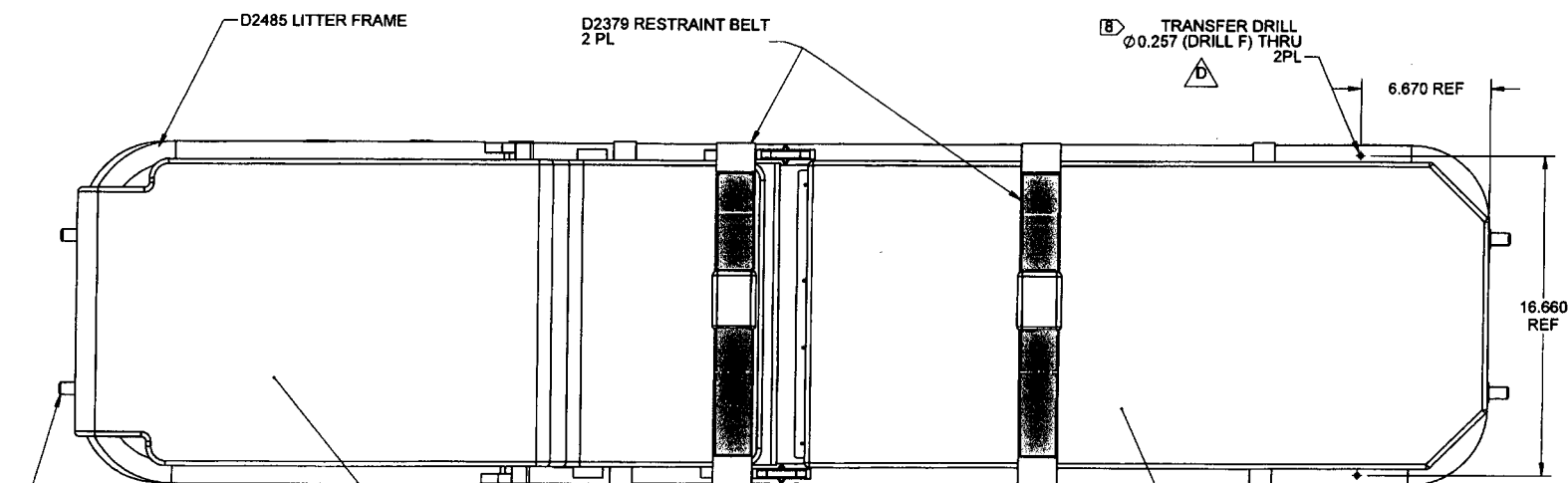
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 25.73 Lbs

D	Ø0.257 HOLES WERE Ø0.191 HOLES, 2PL (ZN C3-2), CREATED -1 AND -041 ASSEMBLIES, NEW DWG FORMAT	DB	13.03.27
C	ADD ALTERNATE FOR D2484, MS SCREWS, TAPPED HOLES AND 5.00 WAS 5.34	KE	06.11.21
B	ADDED Ø0.191 HOLES	KE	98.06.09
A	NEW ISSUE	NA	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2370 REV. D SHEET 1 OF 2 TITLE LITTER ASSEMBLY SCALE NTS COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	DB		
CHECKED	<i>A.P.</i>		
MFG. APPR.	<i>21</i>		
APPROVED	<i>19</i>		
DE APPR.	<i>11</i>		
DATE	13.03.27		

8 7 6 5 4 3 2 1

ITEM	QTY -1	P/N	DESCRIPTION
	X	D2370-1	LITTER ASSEMBLY
1	4	D2374	STUD
2	4	D2378	MOUNTING BOLT
3	2	D2379	RESTRAINT BELT
4	1	D2381-1	LITTER FOOT PAD
5	1	D2381-3	LITTER HEAD PAD
6	4	D2484	LOCK NUT
7	1	D2485	LITTER FRAME
8	4	AN960JD416L	WASHER



D2370-1 LITTER ASSEMBLY

RELEASED
2013-05-16

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2370-1" USING A REMOVABLE TAG AS PER QSI 044 METHOD 6.6
 - 7) WEIGHT: 24.69 Lbs
 - 8) TRANSFER DRILL USING D4812-041 AS TEMPLATE. ENSURE FIT AND REMOVE FOR SHIPPING

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	AP	D2370	SHEET 2 OF 2
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	LITTER ASSEMBLY	NTS
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